

54613 DREV

## Work Order ID 53227



Page 1

October 27, 2009 3:05:36 PM

Item ID: D3278-041

Accept



Setup Start



Revision ID: C

Stop



Item Name: Support Assembly

Start Date: 27/10/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 05/11/2009 Req'd Qty: 40.00

Customer:

Reference:

Run Start



Stop

Approvals: Process Plan: BT Date: 09-10-27 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3278	Rev C
-------	-------

100 0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Rivet spacers with support as per Dwg D3278.

09/12/08 (40)

110 0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

2) 09/12/08

counter  
(40)

120 0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble support as per Dwg D3278. □\*\*\*DO NOT TIGHTEN  
BOLTS\*\*\*□Identify as D3278-041

09/12/09 (40)

**Work Order ID 53227**

October 27, 2009 3:05:36 PM



Page 2

Item ID: D3278-041

Revision ID: C

Item Name: Support Assembly

Start Date: 27/10/2009 Start Qty: 40.00

Required Date: 05/11/2009 Req'd Qty: 40.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

130



QC

Quality Control

Operation  
Description

QC5- Inspect part completeness to step on W/O

Memo

Set Up/  
Run Hours

0.00

0.00

⇒ Sorlulor

Draw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stampcounter  
(440)

f

140



Packaging

Packaging

Identify as per dwg &amp; Stock Location: 471

Memo

0.00

0.00

9/12/14

(400) SP

150



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

A. 09.12.16

PL 09-12-14

(70)

# Picklist Print

Page 1

October 27, 2009 3:05:40 PM

Work Order ID: 53227



Parent Item: D3278-041RevC



Parent Item Name: Support Assembly

Start Date: 27/10/2009

Required Date: 05/11/2009

Comments:

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3278-1RevC

Manufactured

No

100

Each

73.0000

40.0000



Support

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

73

36811

2

43418

25

45401

2

47896

1

51353

43

*9/509/12/08*  
*B53801* ~~38~~ **(3x)**

D3278-2RevC

Manufactured

No

100

Each

43.0000

40.0000



Support

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

43

47197

1

51354

42

*9/509/12/08*  
~~38~~ **40**

D3278-3RevC

Manufactured

No

100

Each

2.0000

40.0000



Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST081

2

50323

2

*53456*

*9/509/12/08*  
~~38~~ **40**

# Picklist Print

Page 2

October 27, 2009 3:05:40 PM

Work Order ID: 53227

Parent Item: D3278-041RevC

Parent Item Name: Support Assembly


Comments:

Start Date: 27/10/2009

Required Date: 05/11/2009

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L4  Nut		Purchased	No			100	Each	5,933.000	80.0000		9/509/12/08	

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

5933

110507

184

111827

5740

112314

9

15924

0

AN4-13A

Purchased

No

120

Each

297.0000

80.0000

Bolt

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

297

107321

1

107534

5

107959

23

109285

37

110552

66

110865

3

111477

9

111925

7

112314

146

17406

0

51764

0

M113359 (OK)

80 Qty pulled

October 27, 2009 3:05:40 PM

Shop Packet Print

Page 2

# Picklist Print

Page 3

October 27, 2009 3:05:40 PM

Work Order ID: 53227

Parent Item: D3278-041RevC

Parent Item Name: Support Assembly


Comments:

Start Date: 27/10/2009

Required Date: 05/11/2009

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD416		Purchased	No			120	Each	4,652.000	160.0000			
												
Washer												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

4652

108161

519

110523

340

111279

101

111916

482

✓112314

3210

16941

0

D2230-1RevG

Manufactured

No

120

Each

153.0000

80.0000



Lug

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FG

153

51566

153

*ES 09/12/08*

*ES 09/12/08*

160

80

October 27, 2009 3:05:40 PM

Shop Packet Print

Page 3

# Picklist Print

Page 4

October 27, 2009 3:05:40 PM

Work Order ID: 53227



Parent Item: D3278-041RevC



Parent Item Name: Support Assembly


Start Date: 27/10/2009

Required Date: 05/11/2009

Comments:

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20426AD3-6  Rivet		Purchased	No			120	Each	2,660.000	160.0000			

*Handwritten signature and date: 10/12/08*

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2660	
105055	2660	

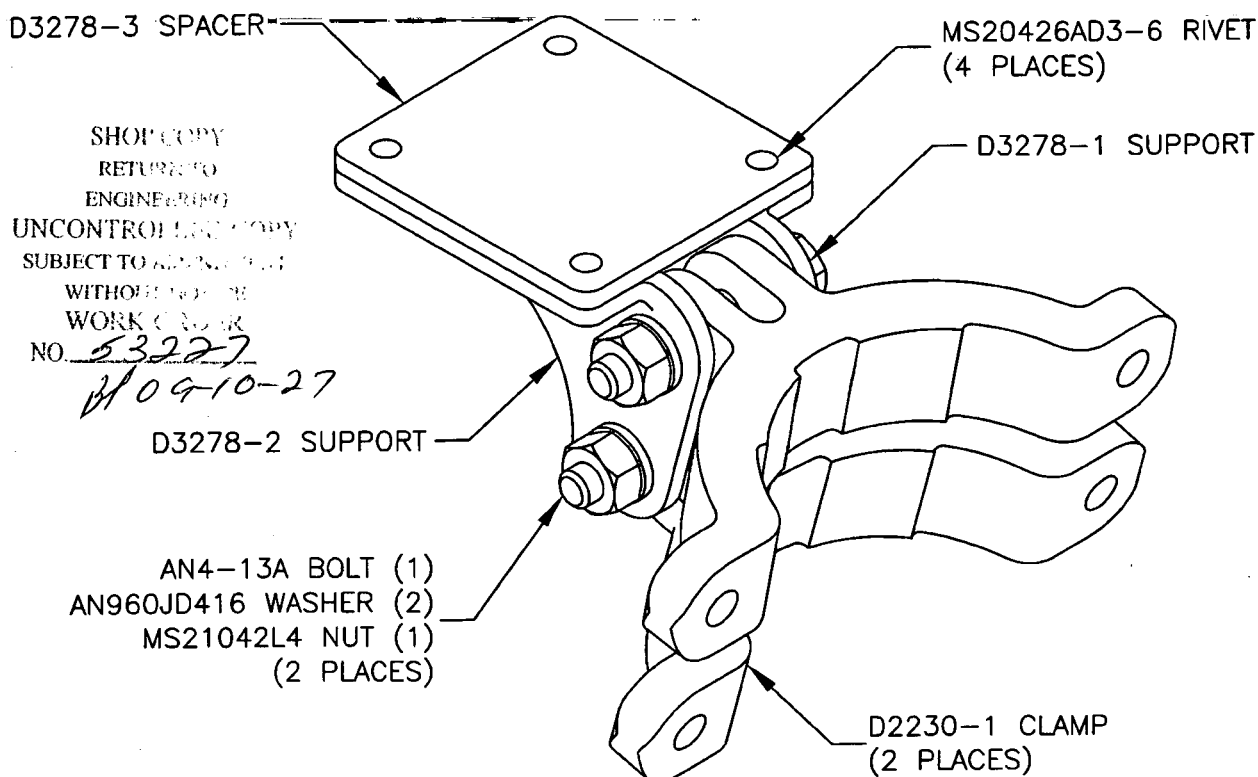
160



DESIGN <i>GP</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

**RELEASED**  
07-08-06

## D3278-041 SUPPORT ASSEMBLY



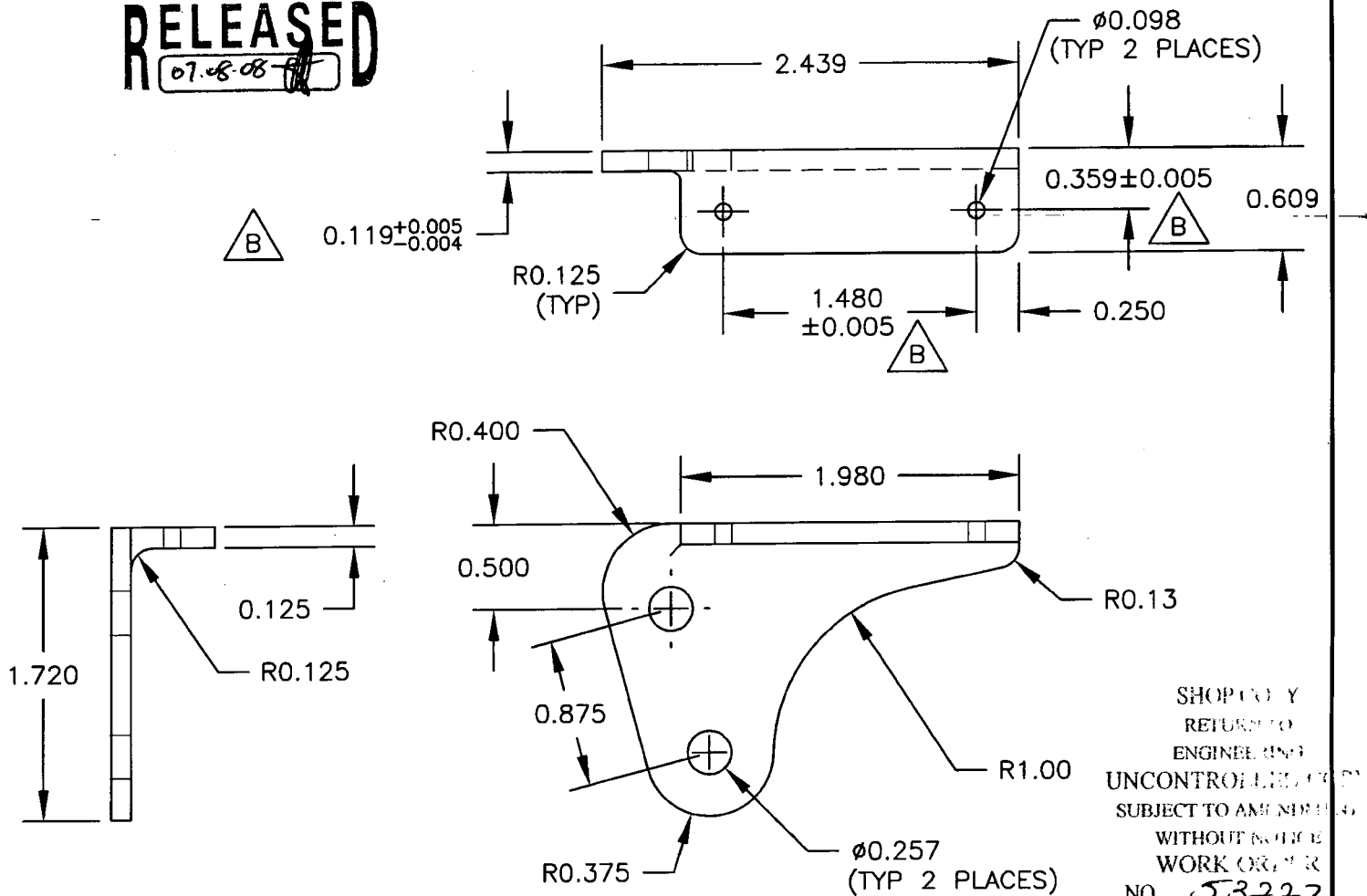
Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

**DART**

DESIGN <i>GP</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

**RELEASED**  
*07.08.08***D3278-1 SUPPORT (SHOWN)****D3278-2 SUPPORT (OPPOSITE)**

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRJT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

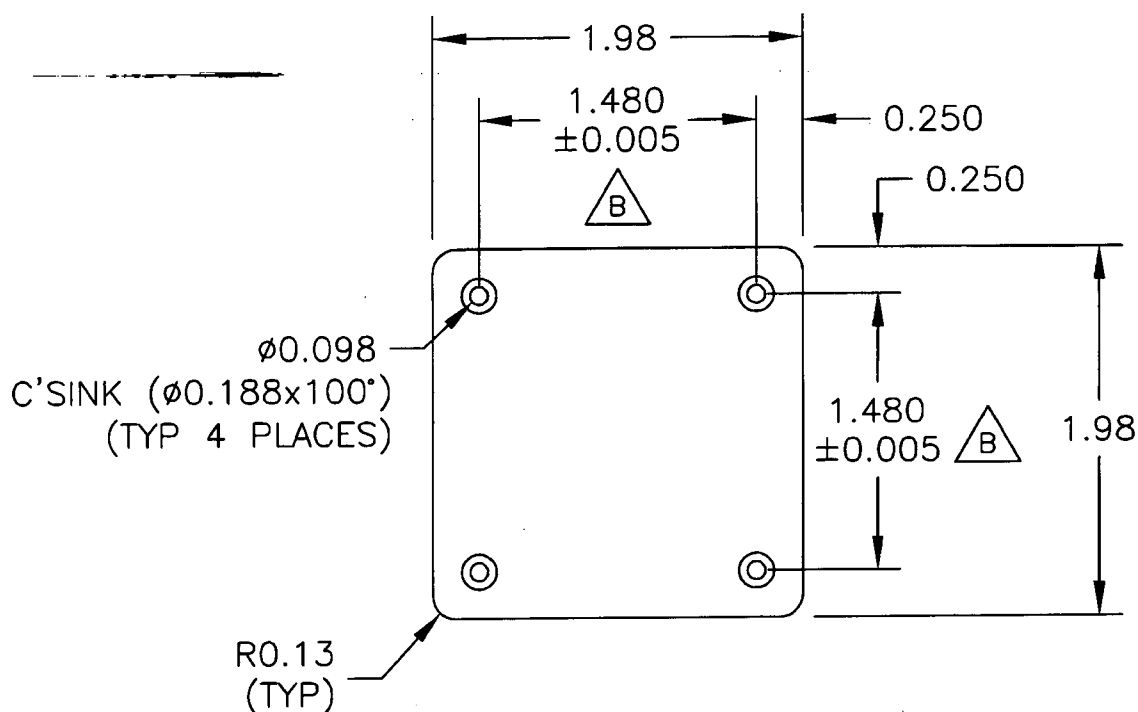
Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



**DART**

DESIGN <i>GP</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>JB</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

**RELEASED**  
07.08.08

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 53227

**D3278-3 SPACER**

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL  
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR  
DELRIN II 150E OR ACETRON GP ACETAL  
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

**Copyright © 2004 by DART AEROSPACE LTD**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	53227
<b>Description:</b> Support		<b>Part Number:</b>	D3278-1
<b>Inspection Dwg:</b> D3278 <b>Rev:</b> C		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000					
0.359	+/-0.005					
0.609	+/-0.010					
0.250	+/-0.010					
1.480	+/-0.005					
R0.125	+/-0.010					
0.119	+0.005/-0.004					
2.439	+/-0.010					
1.980	+/-0.010					
R0.13	+/-0.030					
Ø0.257	+0.005/-0.000					
R0.375	+/-0.010					
0.875	+/-0.010					
0.500	+/-0.010					
R0.400	+/-0.010					
R1.00	+/-0.030					
1.720	+/-0.010					
R0.125	+/-0.010					
0.125	+/-0.010					

<b>Measured by:</b>		<b>Audited by:</b>		<b>Prototype Approval:</b>	N/A
<b>Date:</b>		<b>Date:</b>		<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue      P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	
C	07.09.26	Dimensions updated per Dwg Rev. C	KJ/EC	<i>[Signature]</i>